

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017661**Date Inspected:** 30-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. This QA Inspector observed and/or found the following:

OBG Trial Assembly Yard:

Notification no: 007164.

OBG Seg 11AW and Seg 11BW:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) BP106A-039, 040.
- 2) BP52A-039, 040.
- 3) BP160A-039, 040.
- 4) BP105A-051, 052.
- 5) BP051A-051, 052.
- 6) BP159A-051, 052.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Notification no: 007167.

Lift 10 (W):

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The members are identified as OBG components. The weld designations MT inspected are as follows:

- 1) CA074-200, 201.
- 2) SEG059E-100, 101.
- 3) SEG059D-100, 101.
- 4) SEG063E-100, 101.
- 5) SEG063D-100, 101.

This QA Inspector observed the following work in progress:

OBG Seg 11BW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG067A-044 (side panel to bottom panel – CB side). The welder is identified as 040656 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1. See attached photo for further details.

OBG Seg 11BW and Seg 11CW:

Base metal repair welding after removal of temporary attachments at weld joint no: OBW11B-009 (side panel to side panel – CB side). Welding process was identified as SMAW. The welder was identified as 062935 and was observed welding in the 4G position. ZPMC QC was identified as Zhu Zhong Hai. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-Repair-1. Repair welding was done as per Critical Welding Repair Report (CWR): 1842 Rev-0. See attached photo for further details.

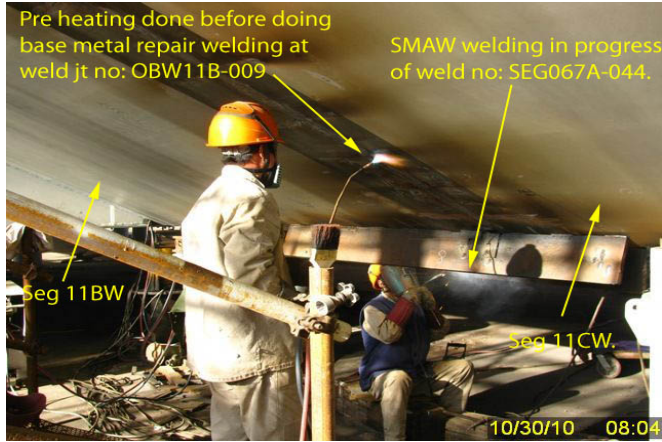
OBG Seg 11BE and Seg 11CE:

The SMAW process on weld joint no: OBE11-010 (Edge panel to edge panel). The welder is identified as 500363 and was observed welding in the 3G position. ZPMC QC was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
